

Work Order ID 78830

Monday, January 16, 2012 1:21:45 PM

78830

Ship Friday

Page 1

Item ID: D3255-042

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Access Panel Assembly

Stop

NS2

Start Date: 1/16/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/16/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: *mf*

Date: 12-01-16

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3255

Rev B

100

0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Weld as per Dwg D3255 ***purge weld***A/R SS ROD
Batch: 4115778 2-Grind Welds Flush

LD 12.01.18 (3x)

110

QC10- Inspect visual per QSI004- ground welds

0.00

110

QC

Memo

0.00

Quality Control

8 12/01/18

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

8 12/01/18

(43) 212

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78830

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Monday, January 16, 2012 1:21:45 PM

Item ID: D3255-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Access Panel Assembly
 Start Date: 1/16/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/16/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

130

Powdercoat

Powder Coating

Memo

START TIME:

FINISH TIME:

0.00

OVEN TEMPERATURE:

3x Ø m/l 12/04/19

140

QC3- Inspect Part Finish

0.00

140

QC

Quality Control

Memo

0.00

3 12-1-19

150

Small Fab

0.00

150

Small Fab

Small Fab

Memo

0.00

1-Bond D3255-5 gasaket to d3255-042 using Dow coming adhesive as per Dwg
 D3255A/R 736 DOW CORNING ADHESIVE

Batch: M116664

12/01/19 ③

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 78830

Monday, January 16, 2012 1:21:45 PM

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Page 3

Item ID: D3255-042 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Access Panel Assembly
 Start Date: 1/16/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/16/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
				512601/20		(X3)			
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>176</u> Memo	0.00 0.00							
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

12/1/20 3
 12/1/20 AJ
 MK
 12-01-20

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Monday, January 16, 2012 1:21:45 PM

Page 1

Work Order ID: 78830

Parent Item: D3255-042

Parent Item Name: Access Panel Assembly

Start Date: 1/16/2012

Required Date: 1/16/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:C Removed Manufacturing of D3255-1/-2/-3 06-08-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3255-2 Panel		Manufactured	No			100	Each	3.0000	1				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA025		3							
				75155		3							
D3255-3 Cap		Manufactured	No			150	Each	21.0000	1				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA022		21							
				75969		21							
D3255-5 Gasket		Manufactured	No			100	Each	11.0000	1				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		11							
				72118		1							
				75083		2							
				78536		8							

12-01-17

12-01-17

12/01/19

3

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

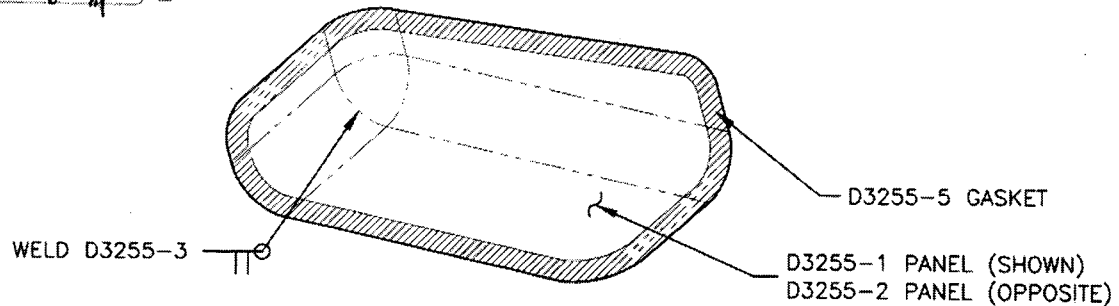
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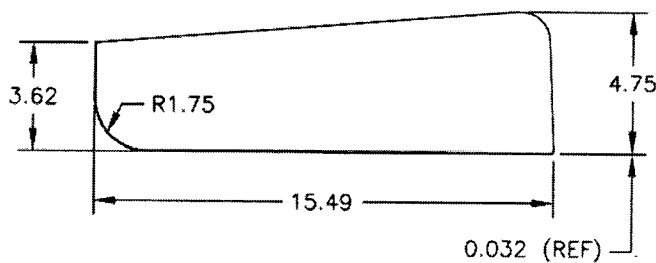
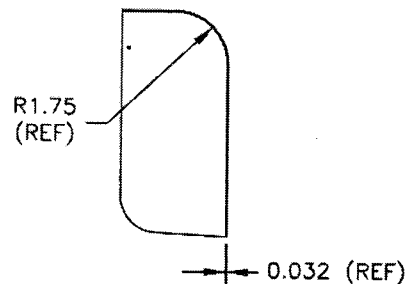
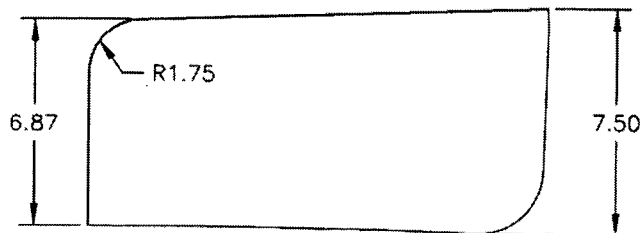


DESIGN T#	DRAWN BY T#	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED if	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED $\phi 0.098$	

RELEASED
05.01.18 #



D3255-041 ACCESS PANEL (SHOWN)
D3255-042 ACCESS PANEL (OPPOSITE)



78830

D3255-1 BEND DETAIL
D3255-2 OPPOSITE

D3255-041/-042 NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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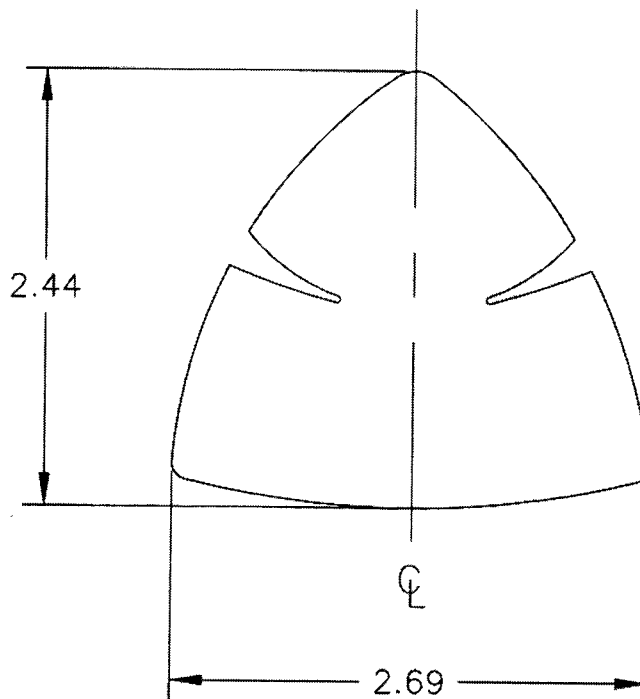
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NOTE: Date & initial all entries



DESIGN DF	DRAWN BY DF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JP	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 2 OF 4
DATE 04.12.06		TITLE TITLE	SCALE 1:1

RELEASED
05.01.18 [Signature]



D3255-3 CAP
FORM TO FIT D3155-1/-2

78830

D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

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Dart Aerospace Ltd

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

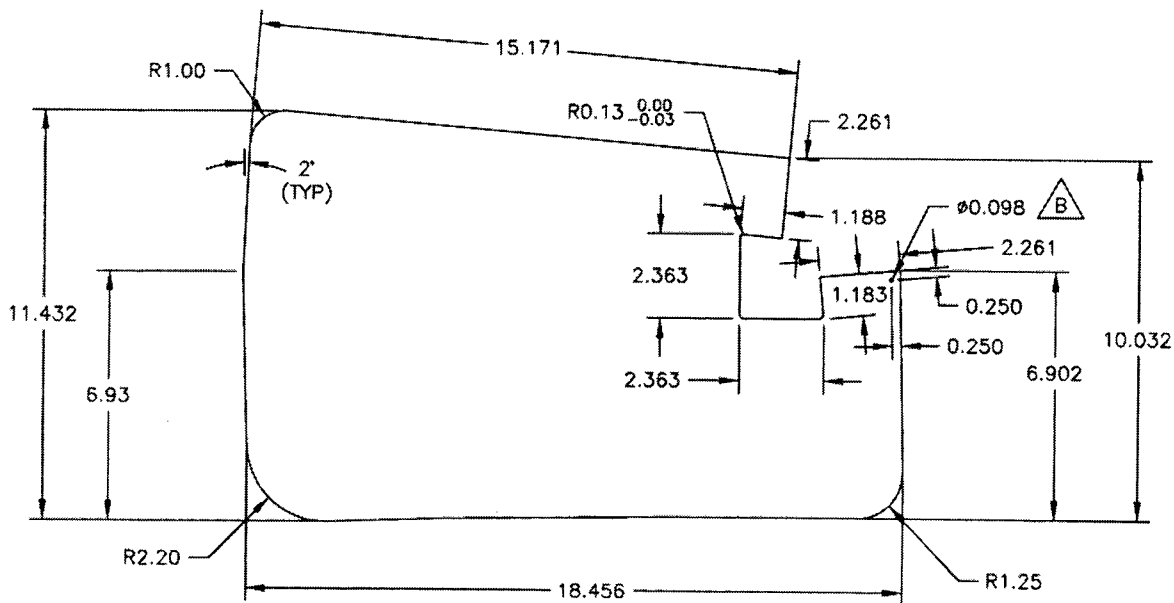
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DESIGN RF	DRAWN BY TF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED P	APPROVED H	DRAWING NO. D3255	REV. B SHEET 3 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED
05-01-18



** 78830*

D3255-1/-2 FLAT PATTERN

D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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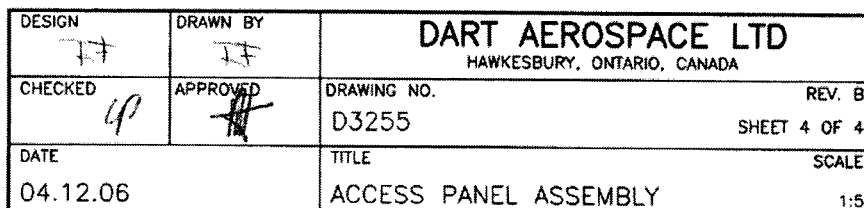
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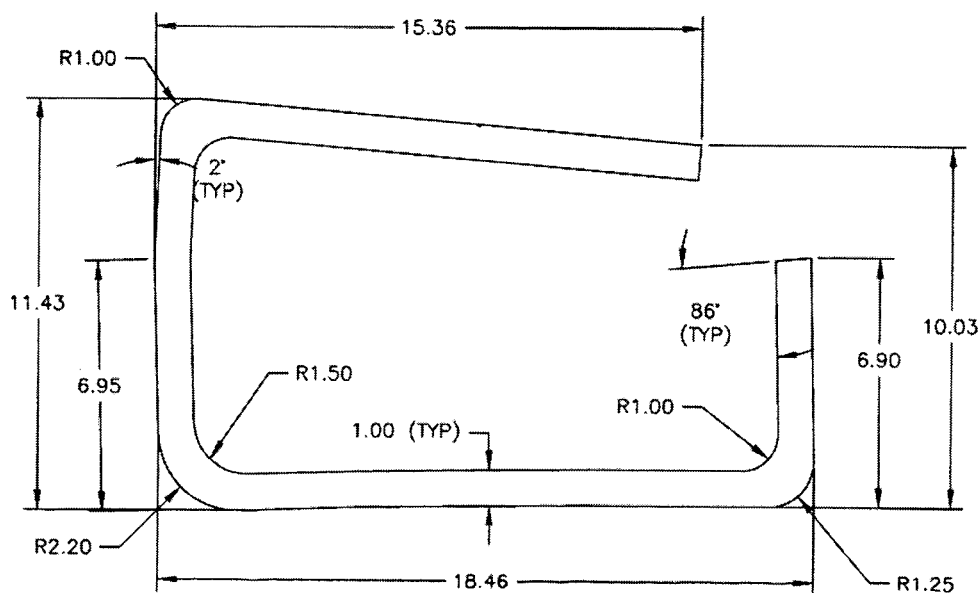
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
05 01 18 #



D3255-5 GASKET

7830

D3255-5 NOTES:

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F
P/N SIL/F 36x36x1/16
POSSIBLE SUPPLIER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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